

Date: Tuesday, 3/11/2008 7:57:37 AM
User: Kim Johnston8B 08/03/24
Split w/o

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BEARING ASSEMBLY		
Job Number	: 37750 -1						
Estimate Number	: 10716						
P.O. Number	:			Part Number	: D3121241		
This Issue	: 3/11/2008	S.O. No.	:	Drawing Number	: D3121 REV E		
Prsh Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type	: MACHINED PARTS	Drawing Revision	: E		
Previous Run	: 37475			Material	:		
Written By	:			Due Date	: 3/31/2008	Qty:	39
Checked & Approved By	: <u>JF</u> 08/03/11			40	Um:	Each	
Comment	: Est Rev:A 04.02.18 New issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MDELRINR12500	DELRIN ROUND BAR 1.25"	
		Comment: Qty.: 0.0546 f(s)/Unit Total : 2.1840 f(s) Material: Ø1.25 Delrin Rod (M-DELRIN-R1.2500)Identify as D3121-25 Batch: M104398	J.F. 08/03/24 (48)
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1-Turn D3121-25 Cap as per Folio FA387	
	2-Deburr		J.F. 08/03/23 (48)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 08/03/23 (48)
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	J.F. 08/03/25
5.0	D312123	Bearing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3121-23 Bearing B37880	8B 08/03/24

ART AEROSPACE LTD	Work Order:	37750
Description: Cap	Part Number:	D3121-25
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

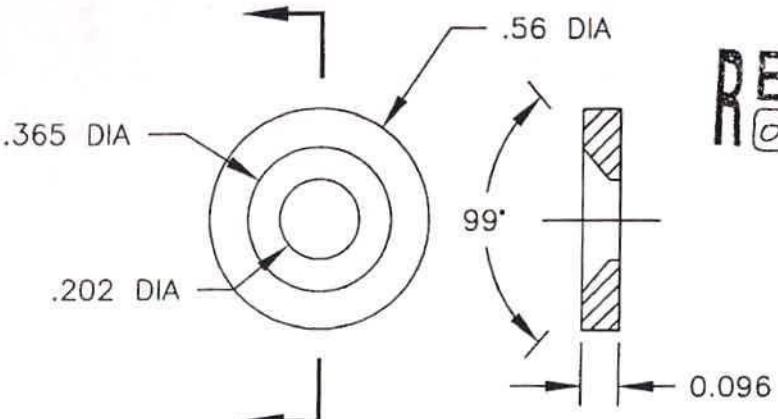
X First Article Prototype

Measured by: <u>JF</u>	Audited by: <u>RL</u>	Prototype Approval: N/A
Date: 08/03/23	Date: 08/03/23	Date: N/A

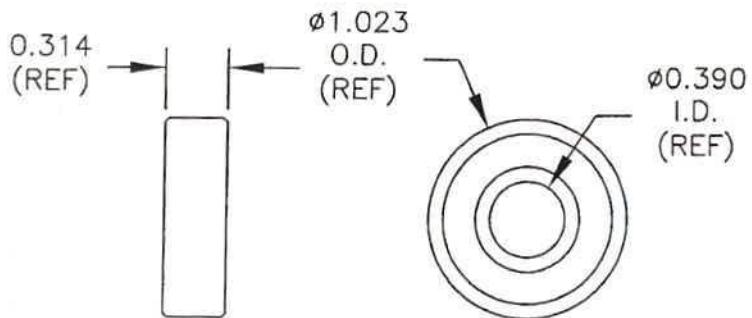
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3121-241)	KJ/RF	
B	06.06.09	Ø1.000 diameter was Ø1.024	KJ/JLM	
C	08.01.16	Dwg Rev. updated	KJ/EC/DD	JK

DART

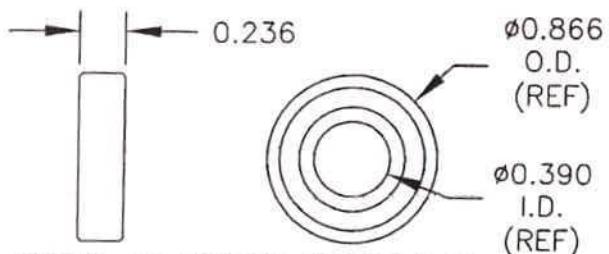
DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D3121	SHEET 10 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:1

**D3121-17 WASHER (SCALE 2:1)**

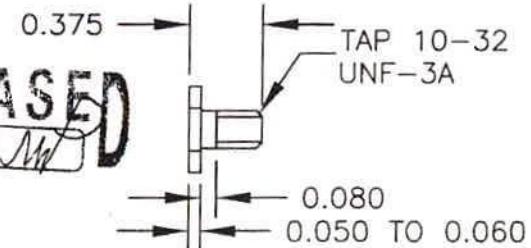
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

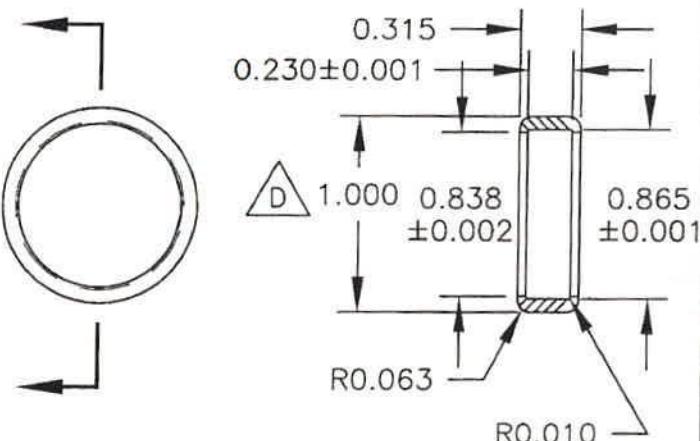
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z
OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

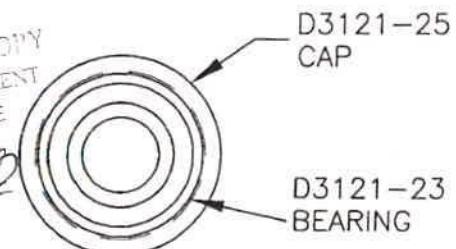
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO 37750

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**